

Work Order ID 74100

Wednesday, September 21, 2011 1:27:47 PM

Page 1

Item ID: D4017-041

Accept

Revision ID:

Item Name: Short Basket Base Assembly (350)

Start Date: 9/21/2011 Start Qty: 1.00

Required Date: 9/30/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 11-09-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4017

C

100

Weld per dwg A/R S.S. rod Batch: 1114649 0.00

Large Fab

0.00

Memo

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

QC

Quality Control

E2/PMB 11/09/28

CP 11-09-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 74100

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Item ID: D4017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Base Assembly (350)

Start Date: 9/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 9:40

OVEN TEMPERATURE: 400 OF

FINISH TIME: 10:10

*****2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

IXD M/L 11/09/30

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ M 11/10/03

M118439

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NOTE: Date & initial all entries




H:\FORMS\Quality Assurance\approved QAWCRWO RevE

Wednesday, September 21, 2011 1:27:54 PM

Parent Item Name: Short Basket Base Assembly (350)

Required Date: 9/30/2011

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| D4017-1  Rib | | Manufactured | No | | | 100 | Each | 3.0000 | 1 | 1 | | 11/09/29 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | WA | | | | 3 | | | | | |
| | | | | | 59957 | | | 0 | | | | | |
| | | | | | 71993 | | | 3 | | | | | |
| D4018-1  Rib | | Manufactured | No | | | | Each | 8.0000 | 1 | 1 | | 11/09/29 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | WA | | | | 5 | | | | | |
| | | | | | 72545 | | | 5 | | | | | |
| | | | | WA005 | | | | 3 | | | | | |
| | | | | | 73031 | | | 3 | | | | | |
| ***D4018-1 is the same as D4017-3*** | | | | | | | | | | | | | |
| D4017-5  Hinge Rib | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 1 | | 11/09/29 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | WA | | | | 4 | | | | | |
| | | | | | 71106 | | | 1 | | | | | |
| | | | | | 72558 | | | 3 | | | | | |

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Picklist Print

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Page 2

Work Order ID: 74100

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-7 Manufactured No

100 Each

5.0000

1

1



Rib



EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

1

69730

1

WA005

4

72008

1

72964

3

D4017-9 Manufactured No

100 Each

12.0000

2

2



Rib



EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

12

70341

2

72554

4

73531

6

D3916-041 Manufactured No

100 Each

4.0000

2

2



Rib Assembly



EL/PMB 11/09/28

B 73635

Location

Loc Qty

Loc Code

WA

4

69161

2

72543

2

2

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3916-5 Manufactured No

100 Each

10.0000

1

1



Light Rib

B 73637

Location

Loc Qty

Loc Code

WA

3

59088

3

WA006

7

72557

7



B / PMB 11/09/28

D4034-041 Manufactured No

100 Each

3.0000

1

1



Aft Upper Rib Assembly

B 73933

Location

Loc Qty

Loc Code

WA006

3

69157

1

72551

2



B / PMB 11/09/28

D4034-043 Manufactured No

100 Each

3.0000

1

1



Fwd Upper Rib Assembly

B 73934

Location

Loc Qty

Loc Code

WA006

3

70241

1

72458

2



B / PMB 11/09/28

D2581 Manufactured No

100 Each

34.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

34

69258

1

69739

2

70766

2

73079

29



B / PMB 11/09/28

| W/O: | | WORK ORDER CHANGES | | | | | |
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Picklist Print

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Page 4

Work Order ID: 74100

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-15

Manufactured No

100 Each

6.0000

1

1



Wide Handle Plate



EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

2

69647

2

WA005

4

69012

1

72550

3

D4016-1

Manufactured No

100 Each

28.0000

3

3



Hinge Half, Base



EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

28

66418

0

68426

3

72009

7

72757

18

D4020-3

Manufactured No

100 Each

0.0000

1

1



Mesh (350 Basket Short, Base)



EL/PMB 11/09/28

D4020-11

Manufactured No

100 Each

6.0000

2

2



End Mesh, Basket



EL/PMB 11/09/28

Location

Loc Qty

Loc Code

WA

6

69648

2

72636

4

2

★ B 7410 35

Wednesday, September 21, 2011 1:27:55 PM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
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Wednesday, September 21, 2011 1:27:55 PM

Page 5

Work Order ID: 74100

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-1 Manufactured No

100 Each

24.0000

3

3



Handle Plate

Location

Loc Qty

Loc Code

WA

12

69518

6

69777

6

WA005

12

73649

12

D2931 Manufactured No

150 Each

586.0000

2

2



Bumper

Location

Loc Qty

Loc Code

ST504

586

46064

586

D4021-5 Manufactured No

150 Each

42.0000

2

2



Blanking Plate

Location

Loc Qty

Loc Code

GA

42

73478

42

AN3-10A Purchased No

150 Each

90.0000

6



Bolt

Location

Loc Qty

Loc Code

ST351

90

117795

90

AN960JD8 NAS1149DN832J Purchased No

150 Each

0.0000

2

2



Washer

2/1MB 11/09/28

3
2

2

73478

6

1117887 11/9/30

Wednesday, September 21, 2011 1:27:56 PM

Shop Packet Print

Page 5

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Wednesday, September 21, 2011 1:27:56 PM

Page 6

Work Order ID: 74100

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,465.000

2

2



Cherry Rivets



u

u/10/03

Location

Loc Qty

Loc Code

GA

928

118626

928

x2

ST321

404

111636

48

117505

321

117601

35

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

2,592.000

6

6



Nut



u

u/10/03

Location

Loc Qty

Loc Code

ST300

2592

117441

24

117601

363

117885

205

118451

1000

x6

118927

1000

NAS1149F0332P

Purchased

No

150

Each

162.0000

12

12



WASHER



u

u/10/03

Location

Loc Qty

Loc Code

ST275

162

117735

63

v d

118354

96

x2

17317

3

| W/O: | | WORK ORDER CHANGES | | | | | |
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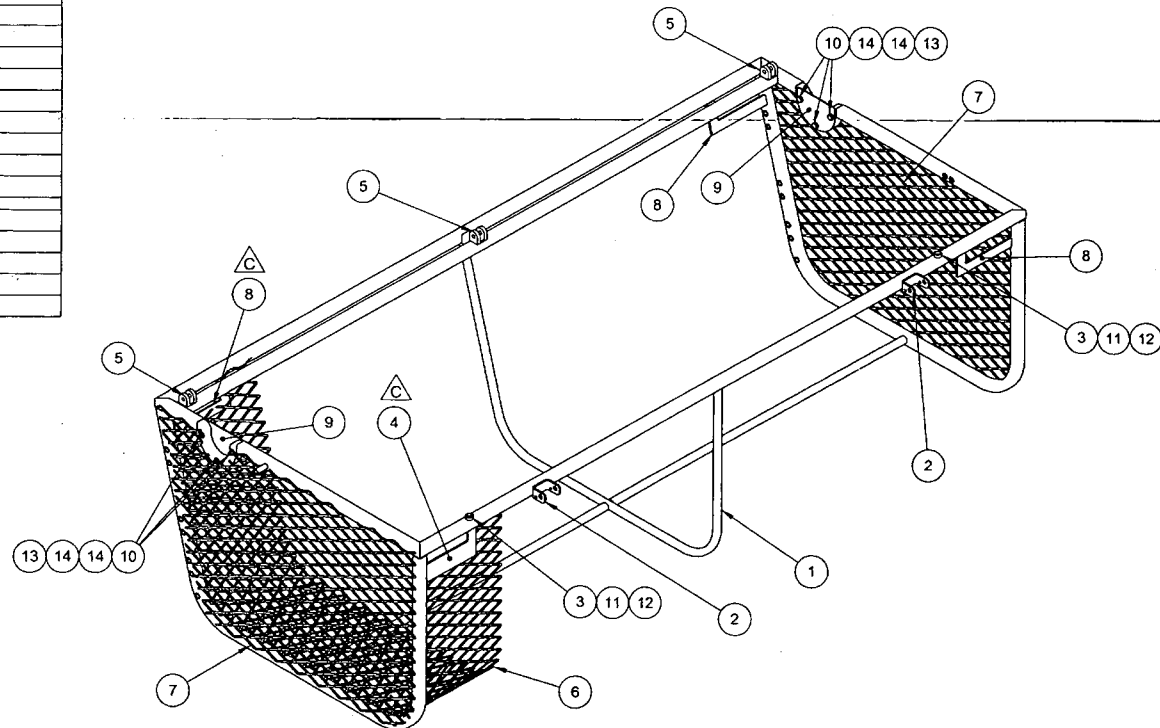
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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|---------------------------------|
| | X | D4017-041 | SHORT BASKET BASE ASSY (350) |
| 1 | 1 | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 2 | D2931 | BUMPER |
| 4 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-3 | MESH (350 BASKET SHORT BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | AN960JD8 | WASHER |
| 12 | 2 | MS20600AD4W3 | RIVET |
| 13 | 6 | MS21042L3 | NUT |
| 14 | 12 | NAS1149F0332P | WASHER |



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.08.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14100
11-09-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

| C | ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES. | MB | 10.07.23 |
|------------|---|-----|----------|
| B | QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3) | JPH | 10.03.25 |
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | S.F.S. | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.07.23 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4017** REV. C
SHEET 1 OF 5

TITLE **SHORT BASKET BASE ASSY (350) _NTS** SCALE

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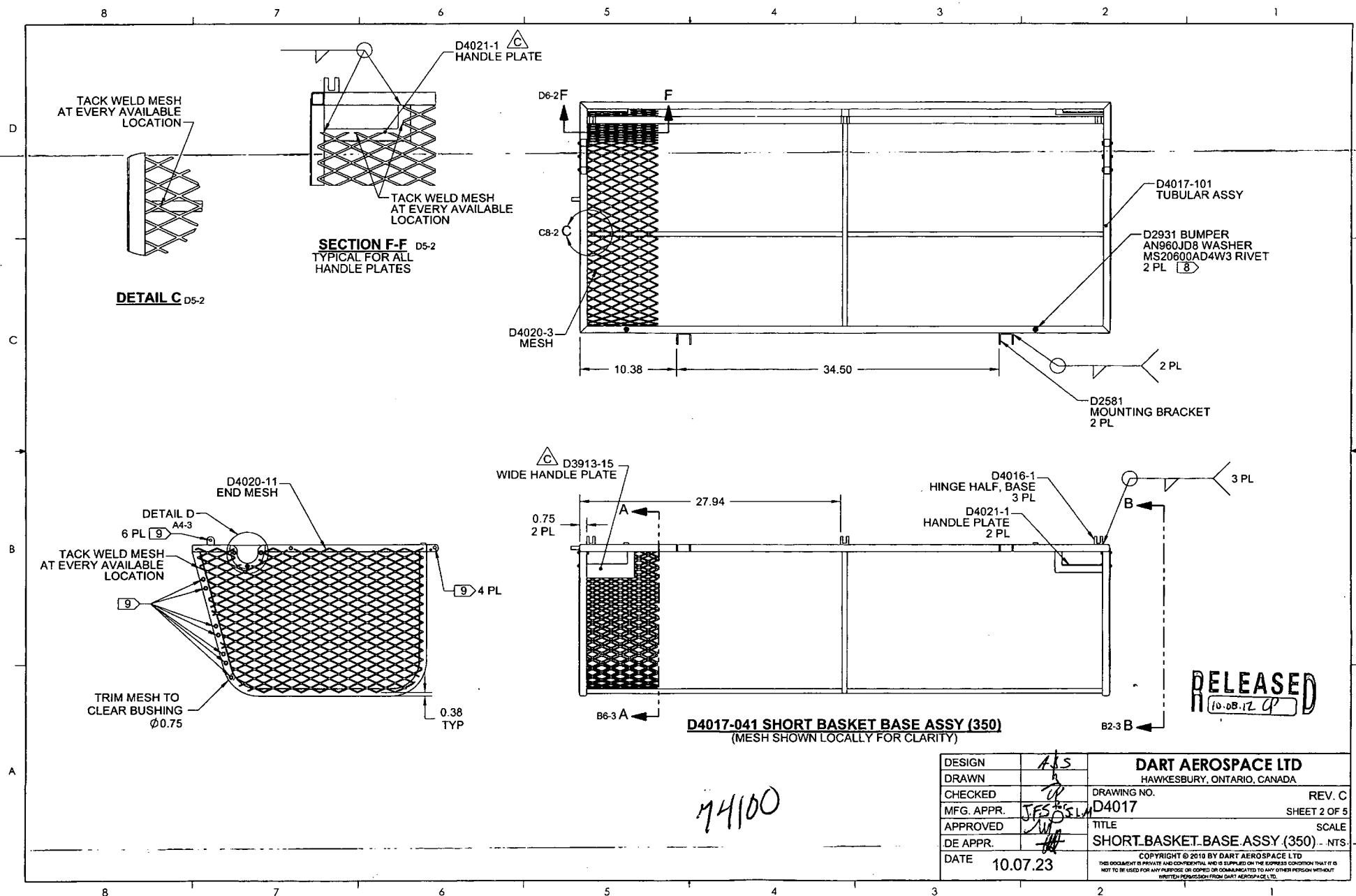
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NOTE: Date & initial all entries



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|--|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | h | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | TP | DRAWING NO. | REV. C |
| MFG. APPR. | JES | D4017 | SHEET 2 OF 5 |
| APPROVED | JW | TITLE | SCALE |
| DE APPR. | W | SHORT.BASKET.BASE ASSY (350) - NTS. | |
| DATE | 10.07.23 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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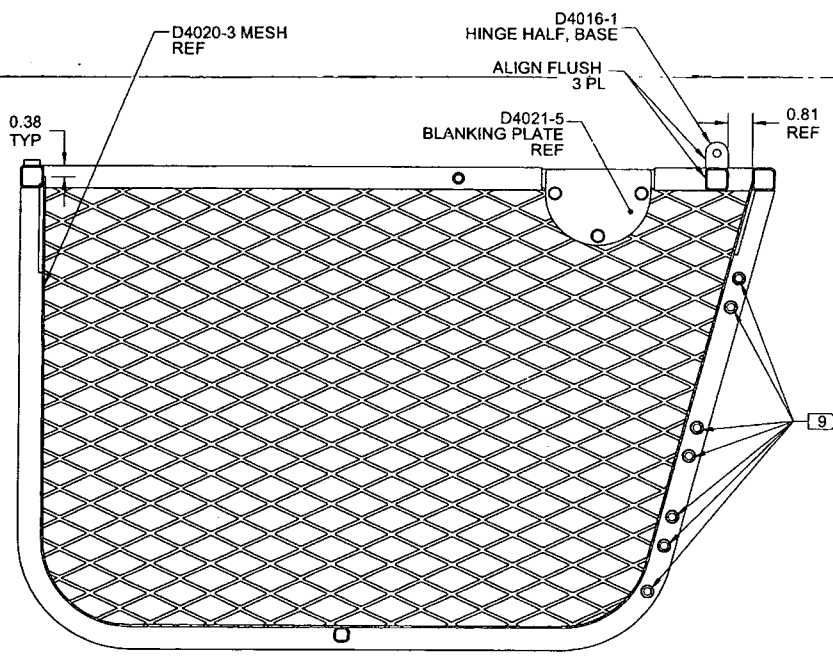
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NOTE: Date & initial all entries

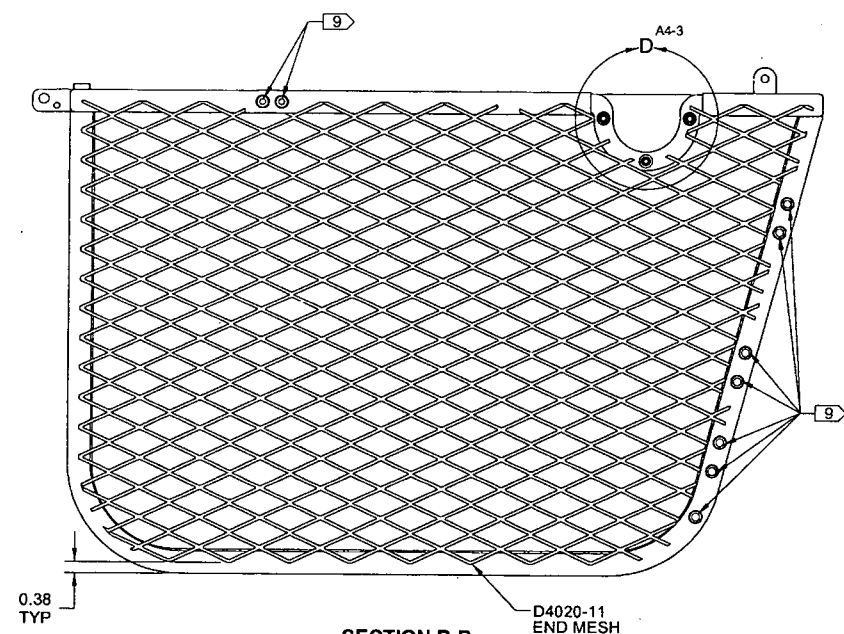
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D
C
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A

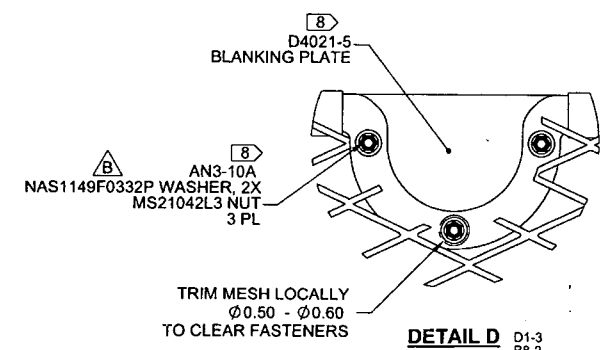
D
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B
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SECTION A-A A2-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

14100

RELEASED
10.08.12 4

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | TOP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JFS | DRAWING NO. D4017 | REV. C |
| MFG. APPR. | JFS | TITLE SHORT-BASKET-BASE ASSY (350) - NTS | SHEET 3 OF 5 |
| APPROVED | JMP | SCALE | |
| DE APPR. | | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
| DATE | 10.07.23 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

8 7 6 5 4 3 2 1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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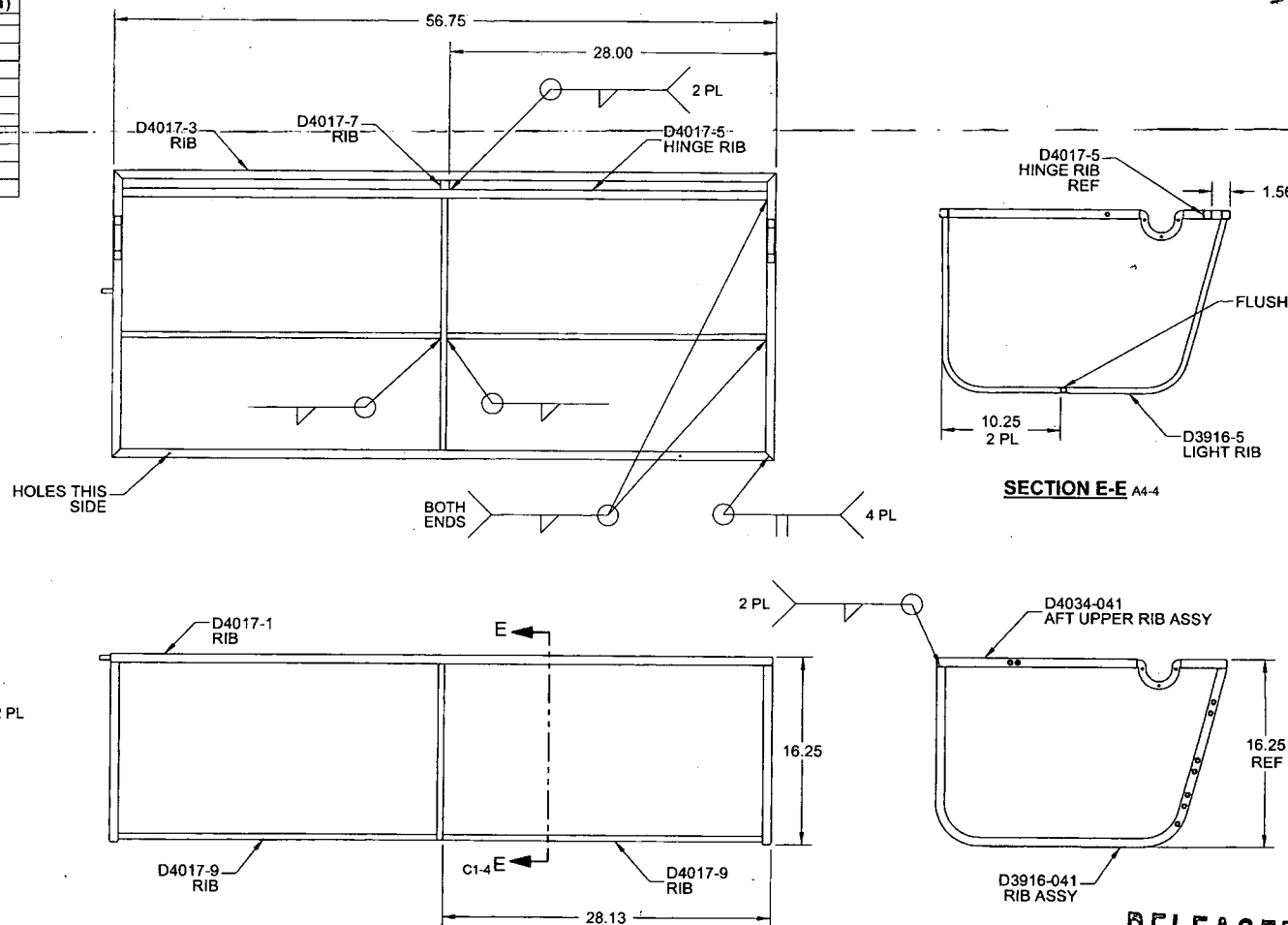
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|---------------------------------|
| | X | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 1 | 1 | D4017-1 | RIB |
| 2 | 1 | D4017-3 | RIB |
| 3 | 1 | D4017-5 | HINGE RIB |
| 4 | 1 | D4017-7 | RIB |
| 5 | 2 | D4017-9 | RIB |
| 6 | 2 | D3916-041 | RIB ASSY |
| 7 | 1 | D3916-5 | LIGHT RIB |
| 8 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 9 | 1 | D4034-043 | FWD UPPER RIB ASSY |



8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

| | | | |
|------------|----------|----------------------------------|--------|
| DESIGN | ALS | DART AEROSPACE LTD | REV. C |
| DRAWN | A | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JP | DRAWING NO. | D4017 |
| MFG. APPR. | SFS | TITLE | SCALE |
| APPROVED | JN | SHORT BASKET BASE ASSY (350) NTS | |
| DE APPR. | JH | | |
| DATE | 10.07.23 | | |

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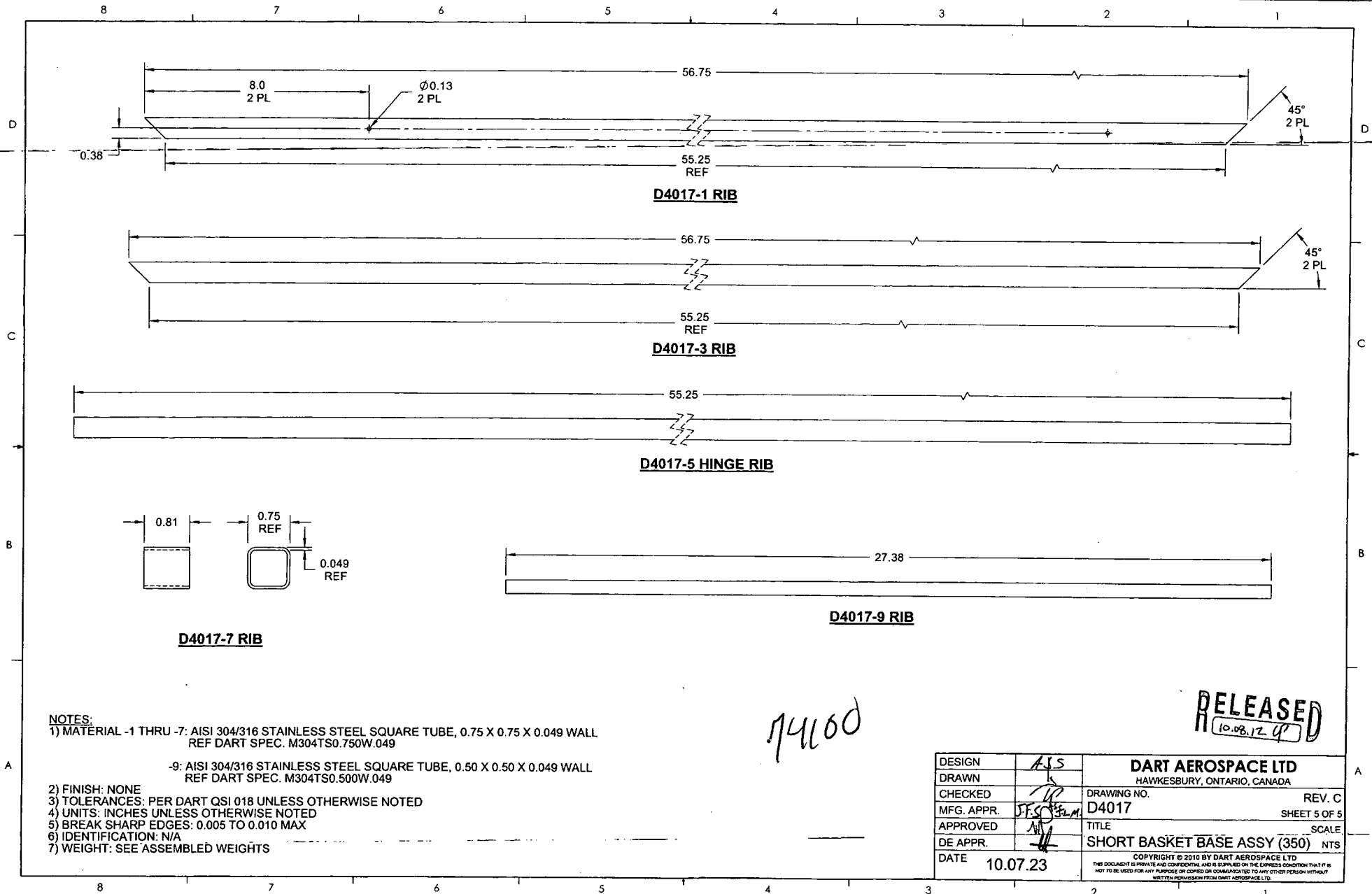
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries